



Dart Aerospace Ltd.
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D3913-041
Job Sheet 211723



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/20

Job Tracking No:

Due Date: 9/11/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/10/20		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	9/10/20		0.00	0.00	QC 9 - 10		OCT 26 2020
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1	9/10/20		0.00	0.00	QC 5 - 10		OCT 26 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS	
							QC 5 - 22	24	
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Container No: S308272



Part: D3913-041

Job No: 211723

Serial No/Batch: S308272

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/23/20

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						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		
						QC 5 - 82		
125	Handfinish - 2-1 Pressure-B4B	1 pcs	9/10/20	0.00	0.29	Handfinish - 2 - 1 - B4B	20-10-27	DAS 34 9-89
						Handfinish - 2 - 2 - B4B		
						Handfinish - 2 - 3 - B4B		
						Handfinish - 2 - 4 - B4B		
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	9/10/20	0.00	0.93	Powdercoat - 1 - B4B		
						Powdercoat - 2 - B4B		
						Powdercoat - 3 - B4B	20-10-28	DAS 34 9-89
						Powdercoat - 4 - B4B		
						Powdercoat - 5 - B4B		
						Powdercoat - 6 - B4B		
						Powdercoat - 7 - B4B		
						Powdercoat - 8 - B4B		
						Powdercoat - 9 - B4B		
						Powdercoat - 10 - B4B		
140	QC 3	1 pcs	9/10/20	0.00	0.00	QC 3 - 10		
						QC 3 - 13		
						QC 3 - 15	20-10-28	DAS 15 9-89
						QC 3 - 17		
						QC 3 - 18		
						QC 3 - 2		
						QC 3 - 28		
						QC 3 - 3		
						QC 3 - 30		
						QC 3 - 34		
						QC 3 - 36		
						QC 3 - 41		
						QC 3 - 51		
						QC 3 - 58		
						QC 3 - 59		
						QC 3 - 68		
						QC 3 - 9		
						QC 3 - 40		
						QC 3 - 19		
						QC 3 - 43		
						QC 3 - 24		
						QC 3 - 61		
						QC 3 - 81		
						QC 3 - 82		
						QC 3 - 87		
150	Handfinish - 4-1-Assembly-B4B	1 pcs	9/11/20	0.00	0.50	Handfinish - 4 - 1 - B4B	20-10-28	
						Handfinish - 4 - 10 - B4B		
						Handfinish - 4 - 11 - B4B		
						Handfinish - 4 - 12 - B4B		

						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
						160 QC 5	1 pcs
QC 5 - 12							
QC 5 - 17							
QC 5 - 18							
QC 5 - 19							
QC 5 - 22							
QC 5 - 24							
QC 5 - 3							
QC 5 - 43							
QC 5 - 49							
QC 5 - 51							
QC 5 - 58							
QC 5 - 68							
QC 5 - 9							
QC 5 - 50							
QC 5 - 30							
QC 5 - 40							
QC 5 - 61							
QC 5 - 81							
QC 5 - 82							
170 Packaging 3-1 - Stock - B4B	1 pcs	9/11/20	0.00	0.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		

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9-89

1120-10-28

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA	1	9/11/20	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77

DAS
21
9-15

OCT 28 2020

Part Op **100** - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
140 - QC3- Inspect Part Finish
150 - Assemble as per dwg - Pick Kit
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5304274
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5300929
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	526768 5267768
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5307060
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5306796
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5300937
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5307501
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5306108
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	52472895
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5250092
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5307637
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5308093 v2
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	1x 5301533 / 2x 5307636
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5302679
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5302829
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5289507
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5256752
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5258116-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5265355
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5201836
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5306403
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	9	0
	D3913-1	1	6	0
	D3913-15	1	20	0
	D3913-3	1	6	0
	D3913-7	2	12	0
	D3913-9	1	7	0
	D3916-041	2	0	0
	D3916-5	3	3	0
	D4016-1	3	27	0
	D4017-7	3	45	0
	D4017-9	2	6	0
	D4020-11	2	2	0
	D4021-1	3	18	0
	D4034-041	1	2	0
	D4034-043	1	0	0
	D4672-1	2	34	0
	M304EX0.75-16F	32	838	0
	AN3-10A	6	196	0
	D2931	2	459	0
	D4021-5	2	10	0
150-Handfinish - 4-1-Assembly-B4B	MS20600-AD4W3	2	313	0
	MS21042L3	6	1,057	0
	NAS1149F0332P	12	1,905	0
	NAS1149FN832P	2	1,343	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					